

over 2839

2839



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200

RBT18547-1
Job Sheet 172914



Part No: RBT18547-1

Job Qty: 2 ea

Part Name: Body



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/22/18

Job Tracking No:

Due Date: 3/16/18 *4-23*

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT18547 REV 4A IPP REV A 18.02.21 NEW ISSUE FK VERIFY DP

Ship Via:

ds

*SWP
5-10*

high

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		3/15/18	0.00	0.00	Start Up Machining-3		<i>18-5-7</i>
110	CNC Lathe	2 pcs		3/16/18	0.00	2.00	MORI SL-154		<i>18-5-7</i>
120	QC	2 pcs		3/16/18	0.00	0.00	QC2 Machining-4		<i>18-5-7</i>
130	QC	2 pcs		3/16/18	0.00	0.00	QC8 Machining-4		<i>18-5-7</i>
150	Outsource	2 pcs		3/16/18			ATG001-VC		<i>18-05-08</i>
160	Packaging	2 pcs		3/16/18	0.00	0.00	Packaging2		<i>18-5-7</i>
170	QC	2 pcs		3/16/18	0.00	0.00	QC6		<i>18-5-7</i>
180	Packaging	2 pcs		3/16/18	0.00	0.00	Packaging3-1		<i>18-5-7</i>
190	QC21-SA	2 Ea		3/16/18	0.00	0.00	QC21		<i>18-5-7</i>

18-05-08
18-5-7
18-5-7
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18-5-7
18-5-7
18-5-7
18-5-7
18-5-7

Part Op 110 - 1-Machine as per DWG. FOLIO REV: *931* DWG REV: *2-Debur*
Descriptions: 120 - Engrave T/N Using Marktronic engraver as per DWG.
150 - -Issue P/O to ATG : *PO039831* -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.875	6061-T6 Round Bar .875"	.5660 ft (.283 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R0.875	<i>3 1/2</i>	40	0

Part Specifications



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

not be found.

Plex 2/22/18 3:21 PM Dart.lajeunesse.marie

Container No: S069196



Part: RBT18547-1
Job No: 172914
Serial No/Batch: S069196
Revision: 4A
Inspector:

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

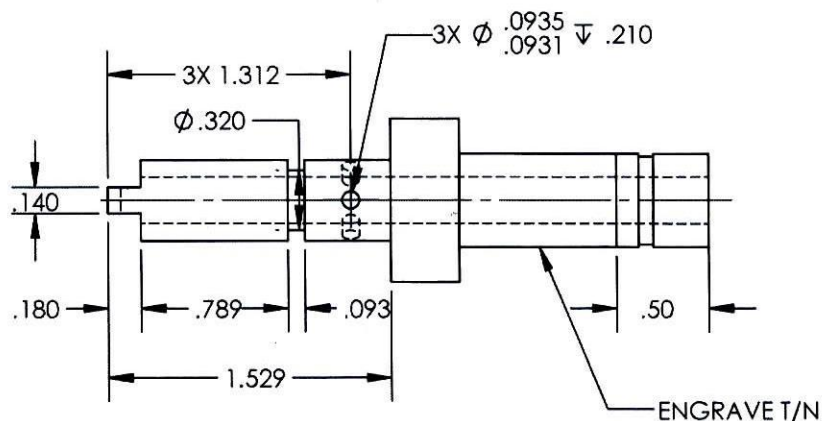
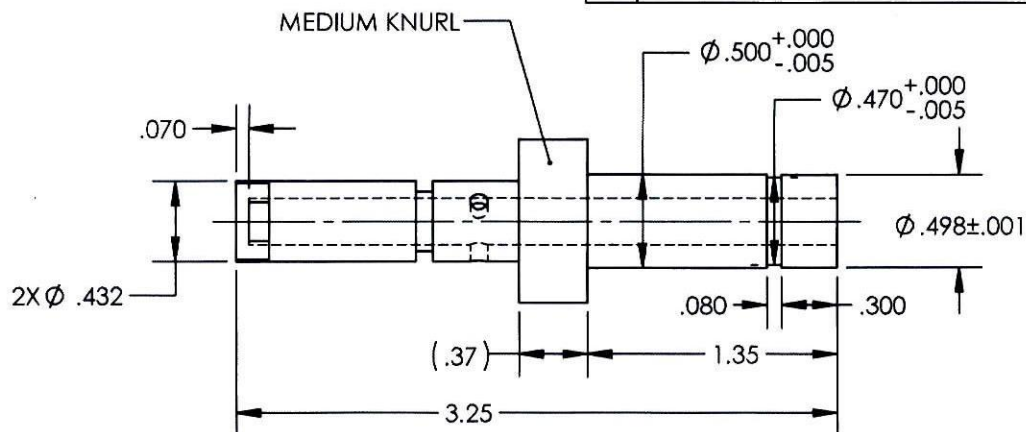
QA Closed: _____ Date: _____

Work Order update only ☐

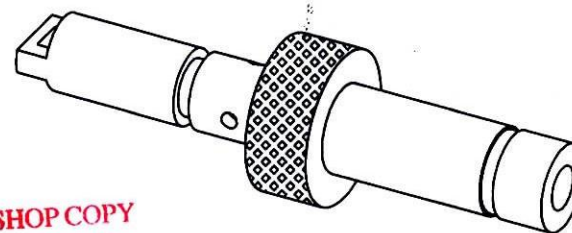
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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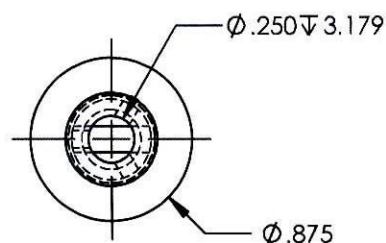
REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CHANGED P/N FROM DB3703-30	4/21/2006	COLE	APPROVED
2	IMPLEMENTED NEW DWG. FORMAT. DELETED -3 FERRAL & TWO OF -1 HOSE RIBS. REDUCED FROM TWO PAGES TO ONE. ADDED ASSY DRAWING.	5/19/2008	WP	DW
3	CH'D CENTER HOLE FROM $\phi .225$ TO $\phi .250$, CH'D $\phi .065$ DIM TO $\phi .070$ ON -1 PER GE. ADDED HEAT SHRINK TO BOM & LABEL NOTE ON ASSY.	2/10/2010	RJC	RW
4	INCREASED STEM LENGTH FROM .81 TO 1.35 TO WORK WITH COUPLING, DELETED BARB, ADDED GROOVE.	8/1/2012	JAG	



(1)
BODY



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 172914 MJS
18-02-22



RED BARN MACHINE	
T/R GEAR BOX DRAIN TOOL	
DWG NO.	RBT18547-1 REV 4A
MAT'L 6061	DRAWN BY: COLE
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Well</i>
.XXX ± .005 FRACTIONS ± 1/32	HEAT TREAT
.XX ± .01 ANGLES ± .5°	FINISH RED ANODIZE
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC MIL-A-8625F, TYPE II, CLASS II
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
	SEE SHT 1
SCALE 1:2	DATE 2/5/2003 SHEET 2 OF 2

8/00

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER : _____							

DART AEROSPACE LTD		Work Order:	172914
Description: Body		Part Number:	RBT18547-1
Inspection Dwg: RBT18547-1		Rev: 4A	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.070	±.005					
.432	±.005	.432	✓		mic	SL-9
.37	±.01	.371	✓		VERW	SL-1
3.25	±.01	3.251	✓			
1.35	±.01	1.35	✓			
.080	±.005	.08	✓			
.300	±.005	.300	✓			
.498	±.001	.4983	✓		mic	
.470	+0 -.005	.468	✓			
.500	+0 -.005	.4983	✓			
Ø.250	±.005	.255	✓			
3.179	±.005	3.179	✓			
.875	±.005	.877	✓			
.140	±.005					
.180	±.005					
.789	±.005					
.093	±.005	.093	✓			
Ø.0935	+0 -.0004	.093	✓			
1.312	±.005	1.312	✓			
.320	±.005	.320	✓			
.140	"	Ø.142"	✓		Vendor CNC-19	
.180	"	Ø.182"	✓		"	

Measured by:	16 / 18/5/8	Checked by:	B.C.	QC Inspector:	
Date:	18-5-7	Date:	18-05-08	Date:	

Engineering Approval: (if necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039831**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO039831
PO Date: 5/8/18
Due Date: 5/10/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	176630	RBT400315-7	Bolt -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	5/10/18	10 pcs	0 pcs	10 pcs	\$6.6666666/pcs	\$66.67
Line Item Note *asap*										
2	173761	RBEM642V4001102-1	Base Plate -Issue P/O to Groupe Altech: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Certificate of Conformity is required	Firmed	5/10/18	4 pcs	0 pcs	4 pcs	\$7.50/pcs	\$30.00

CT

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	173355	RBT400313-9	Shoe -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	5/10/18	8 pcs	0 pcs	8 pcs	\$6.6666666/pcs	\$53.33
9	172914	RBT18547-1	Body -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	5/10/18	10 pcs	0 pcs	10 pcs	\$12.00/pcs	\$120.00
10	171714	269T9310-3	Handle -Issue P/O to Groupe Altech: P/O -Zinc plate, ASTM B633 TYPE 2 SC2 -Color BLACK -Certificate of Conformity is required	Firmed	5/10/18	5 pcs	0 pcs	5 pcs	\$18.00/pcs	\$90.00
Grand Total:										\$540.00

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

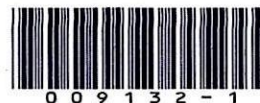
Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 5/9/18 5:34 PM dart.tsimiklis.chrisoula

CZ



Certificat de Conformité / Certificate of Compliance



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

009132 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax:.

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
11-May-2018		Curtis Anderson		39831				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBT400315-7 Rev.	RBT400315-7 01 -BLACK OXIDE ON SST MIL-DTL-13924C BLACK OXIDE FINISH MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	10	10	0	0	0
2	RBEM642V4001102-1 Rev.	RBEM642V4001102-1 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS ZINC PLATE ASTM B633 TYPE 1 SC2	ZINC CH	4	4	0	0	0
5	RBEM631V3027101-1 Rev.	RBEM631V3027101-1 01 -ANO-CLEAR [ANODIZE CLEAR] CLEAR ANODIZE PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEALANT.	ANODIZE CH	6	6	0	0	0
6	RBEM631V3027101-3 Rev.	RBEM631V3027101-3 01 -ANO-CLEAR [ANODIZE CLEAR] CLEAR ANODIZE PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEALANT.	ANODIZE CH	5	5	0	0	0
7	RBEM642V4001102-7 Rev.	RBEM642V4001102-7 01 -ANO-CLEAR [ANODIZE CLEAR] CLEAR ANODIZE PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEALANT.	ANODIZE CH	4	4	0	0	0
8	RBT400313-9 Rev.	RBT400313-9 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	8	8	0	0	0
9	RBT18547-1 Rev.	RBT18547-1 01 -ANO-RED [ANODIZE RED] PER IAW MIL-A-8625 TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	10	10	0	0	0
10	269T9310-3 Rev.	269T9310-3 01 -ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE ZINC PLATE ASTM B633 TYPE 2 SC2	ZINC CH	5	5	0	0	0

008132-1

Bon de Livraison / Packing Slip

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BUYER:

Notes Additionnelles / Additional Notes

Réçu par
Received By

Page 2 of 2